

Date: Monday, 03/11/2008 8:57:12 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE RH (209)		
Job Number	: 43136			Part Number	: D29172		
Estimate Number	: 11597			Drawing Number	: D2917 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/11/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 10/11/2008 Qty: 4 Um: Each		
Previous Run	:						
Written By	: <u>J.F. 08-11-03</u>						
Checked & Approved By	:						
Comment	: Est A 04.07.16 New Issue KJ/JLM est B 07.08.07 ecn930 EC verified by:JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6102010	Saddle Billet
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 6061-T6 8.25x7.95x2.5 Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950" Material: 6061-T6/T651 (QQ-A-250/11) (D6102-010) Identify as D2917-2 Batch: <u>B23641 X 3 PCS</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 3 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet
3.0	MILLING CONV.	Deburr CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

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Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-T. 08/11/16

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

8/11/16
3X

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-T 08/11/17

7.0 POWDER COATING

POWDER COATING



M109152

3X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1 = 30

05

OVEN TEMPERATURE: 320

00

FINISH TIME: 2 = 00

M-T 08/11/17

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

Comment: INSPECT POWDER COAT

08-11-17

(X3)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 434

AS 08/11/18(X5)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18
dfj

Job Completion



M-F 08-11-18

DART AEROSPACE LTD	Work Order:	43136
Description: Saddle RH	Part Number:	D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		,188	,191	,190	,190		
B	0.090	0.110		,090	,100	,100	,100		
C	0.250	0.270		,263	,254	,259	,259		
D	1.599	1.619		1.608	1.605	1.608	1.613		
E	0.180	0.220		,180	,180	,180	,180		
F	0.277	0.297		,286	,287	,278	,278		
G	1.385	1.400		1.386	,378	,393	,391		
H	3.170	3.230		3.205	3.210	3.210	3.210		
I	0.175	0.217		,196	,175	,192	,194		
J	0.470	0.530		R.500	R.500	R.500	R.500		
K	1.498	1.508		1.504	1.499	1.499	1.499		
L	4.436	4.446		4.441	4.446	4.438	4.438		
M	0.257	0.262	DT8683	,258	,258	,258	,258		
N	1.225	1.235		,229	,231	,231	,231		
O	1.103	1.113		1.107	1.009	1.009	1.007		
P	0.470	0.530		R.500	R.500	R.500	R.500		
Q	0.438	0.443	DT8682	,442	,442	,442	,442		
R	0.490	0.510		,503	,516	,503	,503		
S	1.745	1.755		1.752	1.753	1.753	1.753		
T	7.990	8.010		8.002	8.004	8.003	8.003		
U	3.495	3.505		3.500	3.501	3.501	3.501		
V	0.175	0.205		,200	,175	,195	,195		
W	1.990	2.010		2.001	1.995	2.006	2.005		
X	0.760	0.765		,760	,760	,760	,760		
Y	0.307	0.312		,310	,310	,310	,310		
Z	0.615	0.635		,631	,633	,630	,635		
AA	0.177	0.197		,184	,187	,187	,187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	J.F.	Audited by:	J.F.
Date:	08/11/07	Date:	08/11/07

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	J.F.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2917-Z PAR #: N/A Fault Category: Prod Mach NCR: Yes No DQA: A Date: 08/11/18
 (D209-669-014)
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: FJ Date: 08/11/20

NCR: 43136		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/07	2.0	1.385" Bore is at 1.378" ∅.438 holes are shift on one side, so dimension ∅.500 is at .516". R.C. Program on 4th Axis is off.	QSIU12	SCRAP SADDLE. PART IS DRILLED/ INSTALLED BY CUSTOMER AND WE CAN'T VERIFY FIT. Ref Program	J.F. 08/11/07 08/11/16	Q8 08/11/16	QSIU12 08/11/17	S 08/11/17
						7/11/16	S 08/11/17	

NOTE: Date & initial all entries

